

Work Order ID 127549

December-17-14 1:37:27 PM

127549

Page 1

Item ID: D2747 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Set Screw
 Start Date: 12/17/14 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-12-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2747	Rev B

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 26935 3/8"-24 UNF SS Set Screw 7/8" to 1"
 longPossible Supplie: McMaster CarrP/N:92311A639Material release note required

C2 15/01/04 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure material release note is attached

50x 80 15-01-7

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

(50)

DAS
38
9-89

JAN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STO12A</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
26
9-89

JAN 08 2015

MLJ 15-01-09

(Handwritten signature)
15-1-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
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127549

D2747

Required Date: 12/17/14

Required Qty: 50.00

Comments: IPP: B05.08.22ReformatKJ/JLM

[illegible]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Process									
Supplier									
Training									
Transport									
Unapproved									

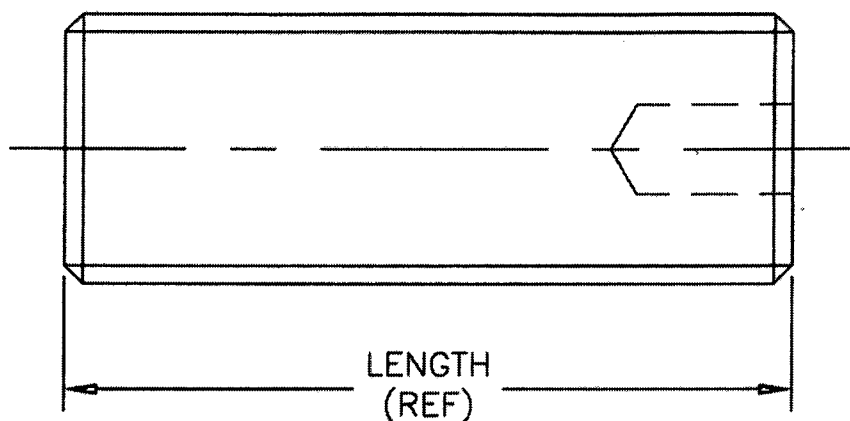
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED
05.08.09 *[Signature]*



D2747 SET SCREW

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*12254 M3
1-1-22*

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FACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER**Purchase Order ID PO26935****Purchase Order Date** 1/6/2015**PO Print Date** 1/6/2015**Page Number** 4 of 5**Order From :**

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name**Vendor Phone**

330 995 5500

Ship To Contact**Ship To Phone****Ship Via:**

Purolator ground ppd

Ship Acct:**Buyer**

Chantal Lavoie

Customer POID**Customer Tax #**

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total:**\$19.1**

10 59915K274

Rod End Bearing

1/8/2015

40.00

Each

\$17.14

\$685.6

Yes

1/8/2015

AS PER DWG D4777 REV. A
B127488

Line Total:**\$685.6**

11 92311A639

SS SET SCREW

1/8/2015

50.00

Each

\$0.66

\$33.1

Yes

1/8/2015

AS PER DWG D2747 REV. B
B127549

Line Total:**\$33.1**

12 71500-90

2939A28 3/8" DRILL 12"
LONG

1/8/2015

1.00

Each

\$20.40

\$20.4

Yes

1/8/2015

Note:

1/6/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO26935

Order Placed By
Chantal Lavoie

McMaster-Carr Number
5509849-01

Page 1 of 1

01/06/20

Line	Product	Ordered	Shipped
1	1761K22 Galvanized Steel Clamp, 4 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	2 Each	2 ✓
2	1761K23 Galvanized Steel Clamp, 5 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	8 Each	8 ✓
3	1317T18 Incandescent Light Bulb, Intermediate-Base, Globe Shape No. S11, 40 Watt, Packs of 1 Your Part Number: 71400-35	2 Packs	2
4	9776K33 1" W X 75' L Hook, Adhesive Back, Beige, Lengths of 75 Your Part Number: B127766	1 Length	1
5	7130K41 Nylon Cable Tie, 6" LG, 1-1/2" Bundle Diameter, 10 lb Break Strength, White, Packs of 100 Your Part Number: B127375	1 Pack	1 ✓
6	91249A146 Black-Oxide Finish Pan Head Phillips Machine Screw, 18-8 Stainless Steel, 6-32 Thread, 3/8" Length, Packs of 100 Your Part Number: B127703	1 Pack	1
7	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B127926	20 Each	20
8	92311A599 18-8 Stainless Steel Cup Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50 Your Part Number: B127910	5 Packs	5
9	91343A100 Type 316 Stainless Steel Serrated-Flange Hex Locknut, 1/4"-20 Thread Size, 7/16" W, 15/64" Overall Height, Packs of 10 Your Part Number: D2484P	5 Packs	5
10	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Your Part Number: B127488	40 Each	40
11	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10 Your Part Number: B127549	5 Packs	5 ✓
12	2939A28 High-Speed Steel Extended-Reach Drill Bit, Uncoated, 3/8", 12" Overall Length, 8.3" Drill Depth Your Part Number: 71500-90	1 Each	1 ✓

SP 15-01-7